

Date: Monday, 1/16/2006 4:19:51 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: CLEVIS
Job Number	: 25533		
Estimate Number	: 10640		
P.O. Number	: <u>N/A</u>	Part Number	: D34535
This Issue	: 1/16/2006	S.O. No.	: <u>N/A</u>
Prsht Rev.	: NC	Drawing Number	: D3453 REV.A
First Issue	: <u>N/A</u>	Project Number	: <u>N/A</u>
Previous Run	: 24935	Drawing Revision	: A
		Material	: <u>N/A</u>
Written By	: <u>SEE COMMENT BELOW</u>	Due Date	: 1/23/2006
Checked & Approved By	: <u>SEE COMMENT BELOW</u>	Qty:	2 Um: Each
Comment	: EST. REV. A 05.11.16 NEW ISSUE EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304R0750 R1.00	Inventory
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Comment: Qty.: 0.1733 f(s)/Unit Total : 0.3465 f(s)
 AISI 304 SS round bar 0.750" dia.
 (M304R0750) 1.000
 Batch: 1717002

ml 06/01/22

3

2.0	HARDINGE	HARDINGE CNC LATHE SMALL
-----	----------	--------------------------



Comment: HARDINGE CNC LATHE SMALL
 1-TURN AS PER FOLIO FA581 & DWG D3453,
 FOLIO REV: N/A
 DWG REV: A

2-DEBURR AS REQUIRED

ml 06/01/22

3

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: INSPECT PARTS AS THEY COME OFF MACHINE

ml 06/01/22

3

4.0	MILLING CONV.	CONVENTIONAL MILLING MACHINE
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Comment: CONVENTIONAL MILLING MACHINE
 1- Drill as per dwg D3453

2-Debur as per dwg D3453

ml 06/01/23

3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 06/01/24

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Drawing Name: CLEVIS

Job Number: 25533

Part Number: D34535

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC2

INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

mk 06/01/23

3

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

M8 06/01/23

7.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *427*

06/01/23

(3)

8.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

505 06/01/24

(3)

06/01/24

Job Completion



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

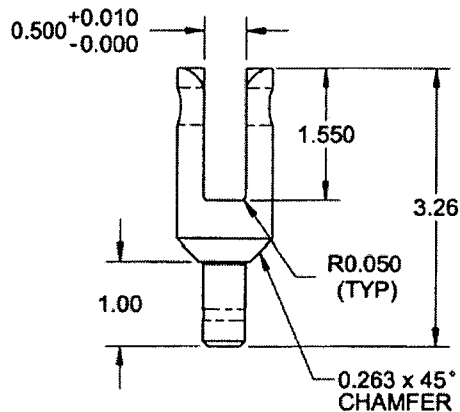
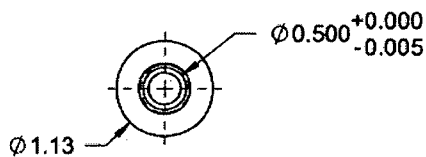
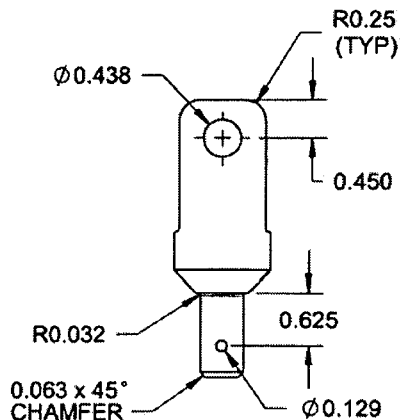
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

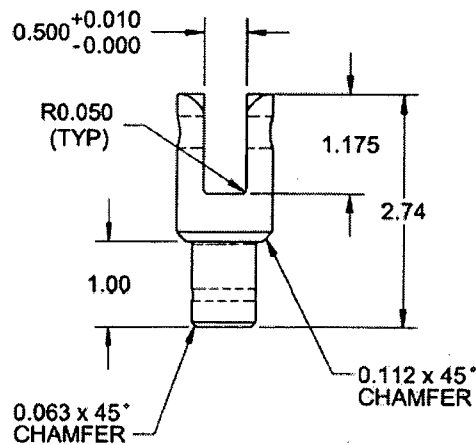
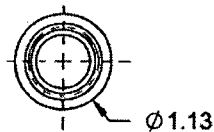
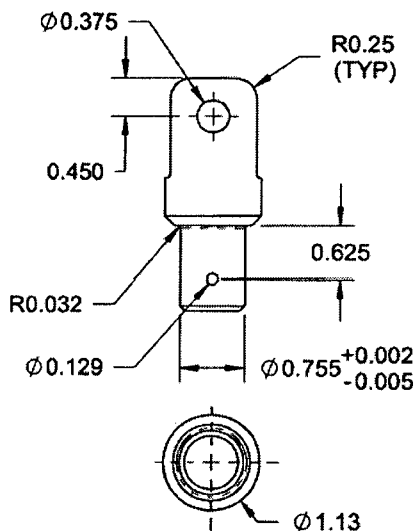
NOTE: Date & initial all entries

DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3453	REV. A SHEET 1 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:2
A	05.09.02	NEW ISSUE	

**D3453-1 CLEVIS****RELEASED**

05.12.09 #

**D3453-3 CLEVIS****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

STOP
RETURN
ENGINEERUNCONTROL
SUBJECT TO
WITHOUT N

WORK ORDER

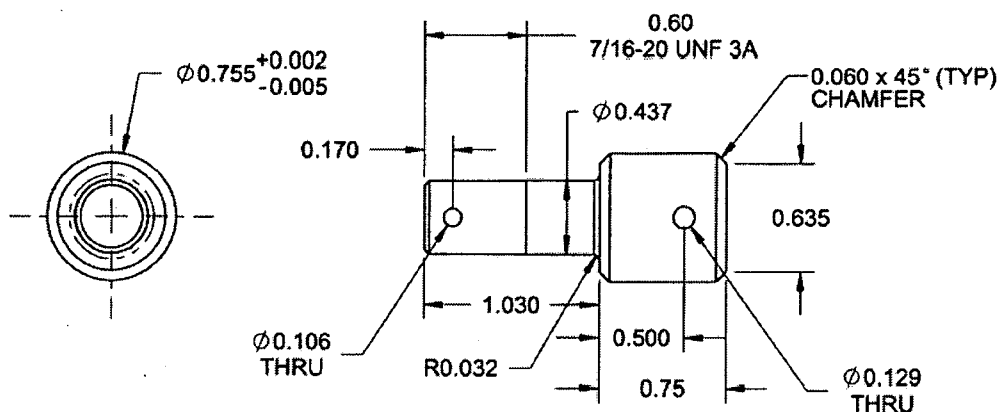
NO. 25533

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DART

DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3453	REV. A SHEET 2 OF 2
DATE 05.09.02	TITLE CLEVIS		SCALE 1:1

RELEASED05.12.09 *[Signature]***D3453-5 PLUG****NOTES:**

- 1) MATERIAL: AISI 304 SS ROUND BAR (REF. DART SPEC. M304R)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL UNMARKED SHARP EDGES 0.005 TO 0.010

SHOP COPY
RETURN TO
ENGINEERINGUNCONT ROLLER
SUBJECT TO AMENDMENT
WITHOUT NOTICE

WORK ORDER

NO. 25533

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